

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015406**Date Inspected:** 30-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Wuzhi Cheng			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG Segment		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, M. Manikandan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD(8AE-8BE)

FCAW Process:

Welding of weld joint – 053 and 054 located on PCMK Retro-G-01-B1/B2/B3, Retrofit plate at side panel of Segment 8AE. Welder is identified as 220066. ZPMC CWI is identified as Wuzhi Cheng. Those locations are identified earlier as out of tolerance for skin flatness by joint survey of CT and ABF. Welding was been performed against ZPMC report GGL-MQ-1666. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

OBG # TRIAL ASSEMBLY YARD (8BE-8CE)

FCAW Process:

Welding of weld joint – 053 and 054 located on PCMK Retro-G-01-B1/B2/B3, Retrofit plate at side panel of Segment 8BE. Welder is identified as 220013. ZPMC CWI is identified as Wuzhi Cheng. Those locations are

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identified earlier as out of tolerance for skin flatness by joint survey of CT and ABF. Welding was been performed against ZPMC report GGL-MQ-1666. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

OBG # TRIAL ASSEMBLY YARD (7CW-7DW)

SMAW Process:

Welding of weld joint – 031 and 032 located on PCMK Retro-G-01-A2, Retrofit plate at side panel of Segment 7DW. Welder is identified as 215326. ZPMC CWI is identified as Wuzhi Cheng. Those locations are identified earlier as out of tolerance for skin flatness by joint survey of CT and ABF. Welding was been performed against ZPMC report GGL-MQ-1666. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112-FCM-1.

OBG # TRIAL ASSEMBLY YARD (9AW-9BW)

FCAW Process:

Welding of weld joint – 019 and 020 located on PCMK SEG049B, Longitudinal diaphragm web to bottom plate of segment 9AW and 9BW. Welder is identified as 045280. ZPMC CWI is identified as Wuzhi Cheng. Welding was been performed against welding repair report B-WR13858. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (9AW-9BW)

SMAW Process:

Welding of weld joint – 017 located on PCMK DP670-001, deck panel I-Rib CJP weld joins 9AW and 9BW. Welder is identified as 033723. ZPMC CWI is identified as Wuzhi Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-b-U3b.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relavant conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By: Manikandan,Murugan

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer